

# Work Order ID 63997 -/

Tuesday, November 23, 2010 9:25:54 AM



Page 1

Item ID:

D3537-1

Accept

Setup Start

Stop



Revision 'D:

Item Name: Wearpad

Required Date: 11/30/2010

11/22/2010

Start Qty: 50.0

Reg'd Qty: 80.0



Cust Item ID: Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: 10-123 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

Operation Description Set Up/ Run Hours

Tool ID

Tool#

Plan Accept Code Qty

Reject Qty

Reject Insp. Number Stamp

Draw Nbr

Revision Nbr

D3537 Rev C

100

Waterjet

FLOW WATER JET

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

B10-11-24

FLOW CNC Waterjet 304.662

1-Cut as per Dwg D3537 □ Dwg Rev: if necessary

C Prog Rev: C 2-Deburr

110

Memo

0.00

0.00

1310-11-04

Quality Control

120

QC

Memo

QC8- Inspect parts - second check

counter

Quality Control

Dart	Aeros	naco	I td
Dail	ACIUS	Date	LIU

W/O:		WORK ORDER CHANGES											
DATE STEP		PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
Part No	):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	_ Date: _					
	Res	solution:	Dispositio	n:	QA: N/C CI	osed:		Date: _					
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCF	1)							
DATE	Description of NC			Corrective Action Section		Verifi	cation	Approval	Approval				
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector				

#### Work Order ID 63997

Required Date: 11/30/2010

Tuesday, November 23, 2010 9:25:54 AM



Page 2

Item ID:

D3537-1

Accept

Setup Start

Revisior ID:

Start Date:

Item Name:

Wearpad

11/22/2010

Start Oty: 50.00

Operation

Description

Reg'd Oty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Date:

Start Run

Stop

Stop

QC:

Date:

SPC (Y/N):

0.00

0.00

0.00

Set Up/

Run Hours

Tool ID

Tool# Plan

Code

Reject Qty

B 10-12-16

Reject Insp. Number Stamp

Work Center ID

130

Sequence ID/

Brake NC Brake NC

NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-

Identify as D3537-1

SB10/11/29

Accept

Qty

Large Fab

Large Fab

Large Fab

Memo

Memo

Description

Batch A/R

2059B Hardcoat

MILL 288 1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any

weld that penetrated through Wearpadif necessary

150

Quality Control

QC10- Inspect visual per QS1004- ground welds

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CHA	OCEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
								Prod Wgr	11/2009 44				
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:					
	R	esolution:	Dispositio	n:	QA: N/C C	osed:		Date: _					
NCR:			WORK ORD	ER NON-CONFORM	IANCE (NCF	?)							
DATE	STEP	Description of NC			ction B	Verifi	cation	Approval	Approval				
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector				

### Work Order ID 63997

Required Date: 11/30/2010

Tuesday, November 23, 2010 9:25:54 AM



Page 3

Item ID:

D3537-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Wearpad

11/22/2010

Start Qty: 50.00 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date:

Date:

Tooling:

Date:

Run Start

QC:

SPC (Y/N):

Date:

Tool #

Stop

Sequence ID/ Work Center ID

160

Operation Description

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

0.00 Somlie

Tool ID

Plan Accept Code Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

170

Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3.5.6) per QSI005 4.3

Memo

0.00

0.00

OVEN TEMPERATURE:

23. Bf 10-12-16.

180

Quality Control

QC3- Inspect Part Finish

= N 10/12/17

Memo

Dart	Aerospace	1 +4	
Dari	Aerospace	LIG	

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH	ANGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cat	egory:	NCR:	Yes I	No DQ	A:	_ Date: _			
	Re	solution:	Dispositi	on:	QA: N	/C Clo	sed:		Date:			
NCR:			WORK OR	DER NON-CONFORM	MANCE (	NCR	)					
DATE	STEP Description of NO			ection B	Verifica		cation	Approval	Approval			
DATE	SILF	Section A	Initial Chief Eng	1 5	Sign & Date		ion C	Chief Eng	QC Inspector			

### Work Order ID 63997

Tuesday, November 23, 2010 9:25:54 AM



Page 4

Item ID:

D3537-1

Accept

Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Wearpad

11/22/2010

Start Qty: 50.00

Reg'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Required Date: 11/30/2010

OC:

Operation

Date:

SPC (Y/N):

Date:

Tool#

Accept

Insp.

Sequence ID/ Work Center ID

190

Packaging

Description

Identify as per dwg & Stock Locatio

Memo

Set Up/ Run Hours

0.00

0.00

Tool ID

Plan Code

Qty

Reject Qty

Reject Number Stamp

Packaging

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/12/20 H)

Dart	Aeros	pace	Ltd
-	1000	Nucc	None II Cod

W/O:			W	ORK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NCR: Ye	s No D	QA:	Date:	
	R	esolution:	Dispositi	on:	QA: N/C	Closed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NO	R)			
DATE	STEP	Description of NC		Corrective Action Section E			fication	Approval	Approval
	0,12.	Section A	Initial Chief Eng	Action Description Chief Eng	Sigr Dat		ection C	Chief Eng	QC Inspector
								U	

## **Picklist Print**

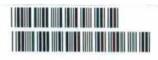
Tuesday, November 23, 2010 9:25:58 AM

Work Order ID: 63997

Parent Item:

D3537-1

Parent It.m Name: Wearpad



Start Date: 11/22/2010

Required Date: 11/30/2010

Page 1

Start Qty: 50.00

Required Qty: 50.00

-					
Co	m	m	en	ts:	

IPP Rev:A

New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	140.6000	0.106	5.578947	6.		
304/316 Sheet 063										HB	10-11-0	4	

304/316 Sheet .063

Locat	tion	Loc Qty	Loc Code
MAT		140.6	
	111323	0	
	115688	3.6	
	115953	137	

115953

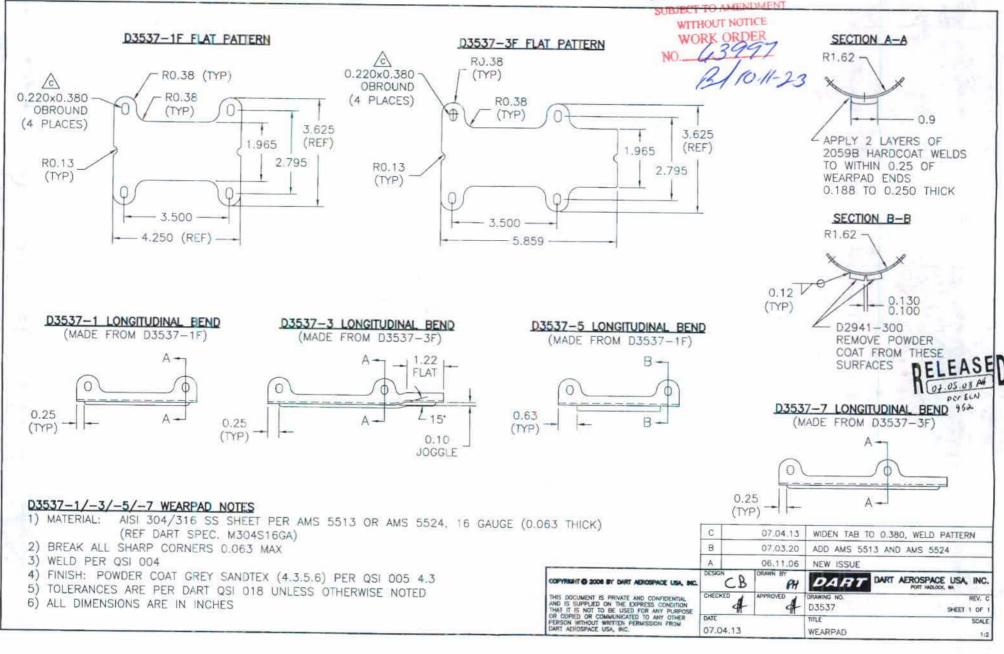
Dart	Aer	osna	Ce	I td
Dant	MCI	osua		LLL

	Copace	Note No No.							
W/O:			WO	RK ORDER CHANGE	S		1		
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	ory:	NCR: Yes	No DQA	۸:	_ Date: _	
	Re	solution:	Disposition: QA			sed:		Date: _	
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC	(	Corrective Action Section	Section B Verifi			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector

DART AEROSPACE LTD	Work Order:	63997
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method o		nments
4.250	+/-0.010	4.246	*		VR 02		
3.500	+/-0.010	3.497	a		V		
1.965	+/-0.010	1.969	8		V		
2.795	+/-0.010	2794	2		V		
3.625	+/-0.010	3.626	عد	414	V		
0.220 x 0.380	+/-0.010	201 × 380	8	7	V	rh	
		7.00		1 31		7	
19		c. 16 a					
		1					
2.							
		Ta.		1.1			
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		4 - 4 - 1		E.			
			575	40.			
	4	7. W. 101	h lyt	P		that the same of t	
Measured by: 35 Date: 10-(1-24)		Audited by: Date: (olu 2)		Prototype A		Approval:	N/A
						Date: N/A	
A 07.03.21 B 07.04.27	Change New Issue Dimensions revis	N. West	187		Revised by KJ/JLM KJ/JLM		Approved

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Dart Ae	rospace	Ltd							• :
W/O:			V	ORK ORDER CHANGI	ES				•
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:							
Resolution:		Disposition:		QA: N/C Closed:			Date:		
NCR:			WORK OR	DER NON-CONFORMA	NCE (NC	₹)			
DATE	STEP	Description of NC	Corrective Action S		etion B Verifi		ication Ap	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	ption Sign Date		ion C	Chief Eng	QC Inspector